

del 0125

Work Order ID 133476

Monday, June 08, 2015 4:11:55 PM

133476

Page 1

Item ID: D3417-5

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Washer

Start Date: 6/01/15

Start Qty: 40.00

40

Cust Item ID:

Required Date: 6/08/15

Req'd Qty: 40.00

40

Customer:

Reference:

Approvals:

Process Plan: MLS

Date: JUN 09 2015 Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

NR1

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool # Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3417

Rev F

100

0.00

100

Hardinge CNC LATHE SMALL

Doosan

Memo

0.13

Doosan Lathe

1-Turn as per Folio FA761

Rev: AA &

Dwg D3417 Rev: F

2-Deburr

40 0 JFL 2015-06-14

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.01

Quality Control

40 0 JFL 2015-06-14

120

QC8- Inspect parts - second check

0.00

120

QC

Memo

0.01

Quality Control

G. 15/06/15

40 0 DAS 08 9-89

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

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Work Order ID 133476

133476

Page 2

Monday, June 08, 2015 4:11:55 PM

Item ID: D3417-5 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Washer
 Start Date: 6/01/15 Start Qty: 40.00 *40* Cust Item ID:
 Required Date: 6/08/15 Req'd Qty: 40.00 *40* Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Identify as per dwg & Stock Location: <u>st 038</u>	0.00							
130									
Packaging	Memo	0.07							
Packaging									
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.01							
Quality Control									

JUN 15 2015
 27
 9:59

MLJ JUN 16 2015

MLJ JUN 16 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

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Picklist Print

Monday, June 08, 2015 4:11:54 PM

Page 1

Work Order ID: 133476

133476

Parent Item: D3417-5

D3417-5

Parent Item Name: Washer

Start Date: 6/01/15

Required Date: 6/08/15

Start Qty: 40.00

Required Qty: 40.00

Comments: IPP Rev:ANew issue08-07-09 JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MDELRINR1.2500		Purchased			No	110	f	12.8000	0.0296	2			

MDELRINR1 2500

DELRIN ROUND BAR 1.25" color: black

Location

Loc Qty

Loc Code

MAT039

12.8

m131782

12.8

2.0 JFL 2015-06-14

DQA: _____ Date: _____

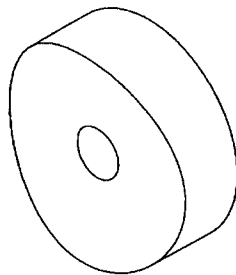


WORK ORDER NON-CONFORMANCE / UPDATE

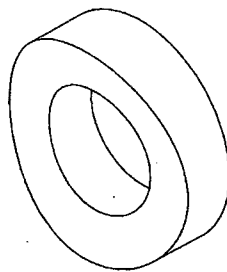
QA Closed: _____ Date: _____

Work Order update only ☐

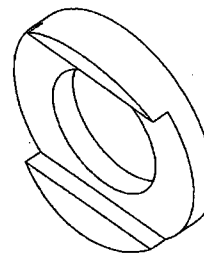
Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																																																												
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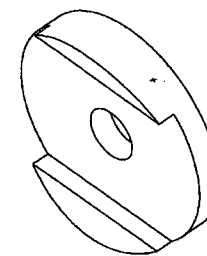
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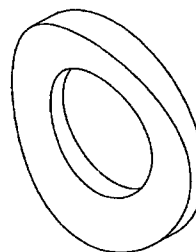
D3417-3 WASHER



D3417-5 WASHER



D3417-7 WASHER



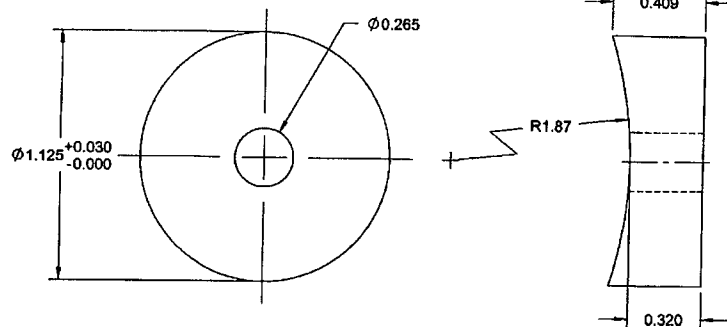
D3417-9 WASHER

NOTES:

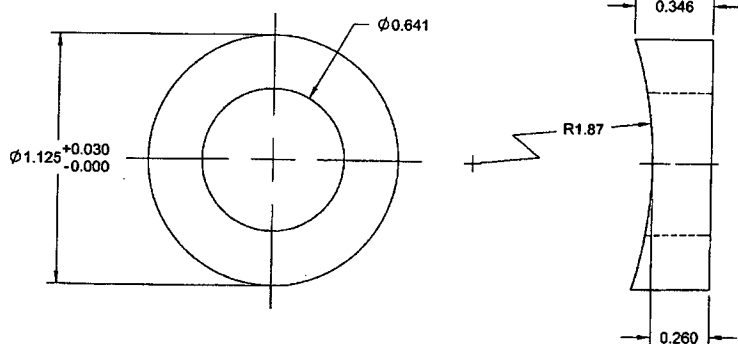
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REF DART SPEC M-DELIN-R
OR BLACK DELRIN II 150E OR ACETRON GP ACETAL, BAR
REF DART SPEC M-DELIN-B
OR BLACK DELRIN II 150E OR ACETRON GP ACETAL, SHEET
REF DART SPEC M-DELIN-S
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: D3417-1, 0.020 lbs
D3417-3, 0.010 lbs
D3417-5, 0.010 lbs
D3417-7, 0.010 lbs
D3417-9, 0.004 lbs

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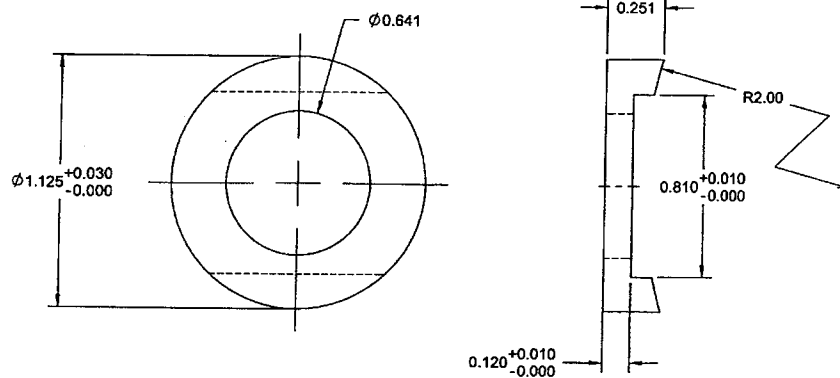
F	ADD D3417-9 (ZN B5-3)	SC	10.07.28
E	ADD D3417-7 (ZN A2-2)	RF	09.06.30
D	ADD -5 WASHER (ZN B2-1, B2-2). REFORMAT TO "B" SIZE & UPDATE TO CURRENT STANDARDS. REASON: INSTALLATION OF NEW TOW RING	AJS	08.07.08
C	REMOVE CBORE, WIDEN	PH	05.06.30
B	CHANGE TO ROUND WASHER	PH	05.06.10
A	NEW ISSUE	PH	05.03.31
REV.	DESCRIPTION	BY	DATE
DESIGN	SC	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	SC		
CHECKED		DRAWING NO.	REV. F
MFG. APPR.		D3417	SHEET 1 OF 3
APPROVED		TITLE	SCALE
DE APPR.		WASHER	NTS
DATE	10.07.26	COPYRIGHT © 2006 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



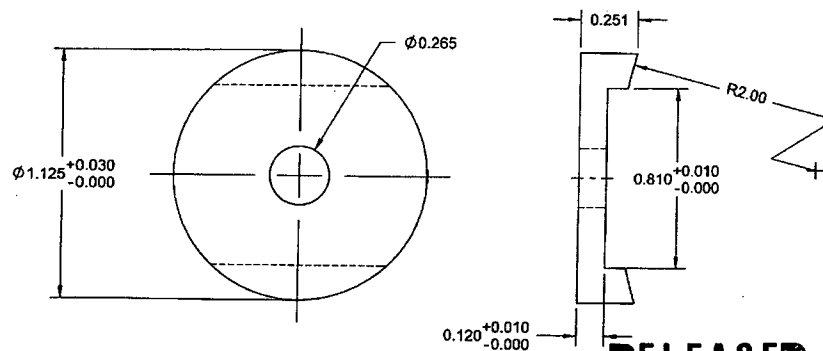
D3417-1 WASHER



D3417-3 WASHER



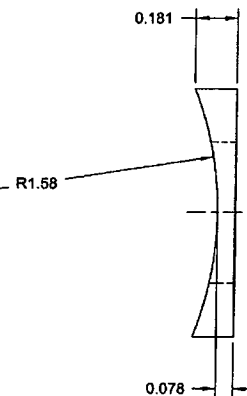
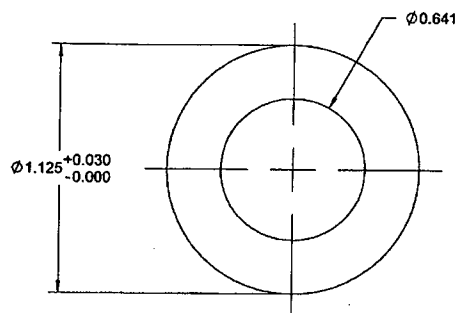
D3417-5 WASHER



D3417-7 WASHER

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MFG. APPR.		D3417	SHEET 2 OF 3
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DE APPR.		WASHER	NTS
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D3417-9 WASHER



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APPROVED		TITLE	SCALE
DE APPR.		WASHER	NTS
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